

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002903**Date Inspected:** 28-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** C.M. Chen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Deck Sections**Summary of Items Observed:**

The Quality Assurance (QA) Inspector, Mahlon Lindenmuth, arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following:

QA Inspector, Lindenmuth, observed the work being performed in Bay 2 of the New OBG. ZPMC personnel were performing various functions related to the fabrication of the OBG Side Plates and Bottom Plates as well as the deck sections in the jig fixture. The fabrication performed includes but is not limited to the preparation of areas where temporary welds for strongbacks are located, bevel preparation and welding of the Complete Joint Penetration welds (CJP) on Side Plates and Bottom Plates, heat straightening of Side Plates and Bottom Plates.

**South Jig Fixture:**

\*Segment 3BE/Panel Point 23/Floor Beam- Caltrans QA Inspector, Lindenmuth, observed ZPMC personnel welding Complete Joint Penetration (CJP) welds identified as SSD19-PP023-131 and SSD19A-PP023-127. The welds join the FL2-1 bottom flange ends to the segments FL1-1 North and South. Caltrans QA Inspector, Lindenmuth, noted some of the welding essential variables and recorded them below.

\*Segment 3AE- ZPMC personnel have set/erected segments 4BE-D6 and 4BE-C5 into the South jig fixture. The segments have not been welded into the jig fixture at the time of this review.

Item	Weld Identification	Applicable WPS	CWI Name	Amperage	Voltage	TravelSpeed	Preheat Temp	Remarks
1	SSD19-PP023-127	WPS-B-P-2214-TC-1	C.M. Chen	165	24	110 mm/min	55 C	Welder ID: 066458

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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### Summary of Conversations:

#### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Lindenmuth,Mahlon	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer

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